

Date: Tuesday, 05/05/2009 8:46:27 AM
User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BUSHING
Job Number :	47733		
Estimate Number :	11041		
P.O. Number :		Part Number :	D2809
This Issue :	05/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2809 REV A1
First Issue :	/ /	Project Number :	N/A
Previous Run :	46438	Drawing Revision :	A1
	Type :	Material :	
	MACHINED PARTS	Due Date :	12/05/2009
Written By :		Qty:	50
Checked & Approved By :	<u>MF 09-05-05</u>	Um:	Each
Comment :	Est C 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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SA 09/05/10



Comment: Qty.: 0.1045 f(s)/Unit Total: 5.2238 f(s)
6061-T6 Round Bar .500"
Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: M111448

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
Machine as per Folio FA204

SA 09/05/10

(56)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/05/10

(56)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MF 09/05/15

(56)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

UMD 09/05/19

(156)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 8:46:27 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 47733

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

START TIME:

9:55

OVEN TEMPERATURE:

320°

FINISH TIME:

10:25

MO 09/05/20

(X50)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-20

(X56)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

49

9/5/21

54

(56X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/21

Job Completion



MF 09-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

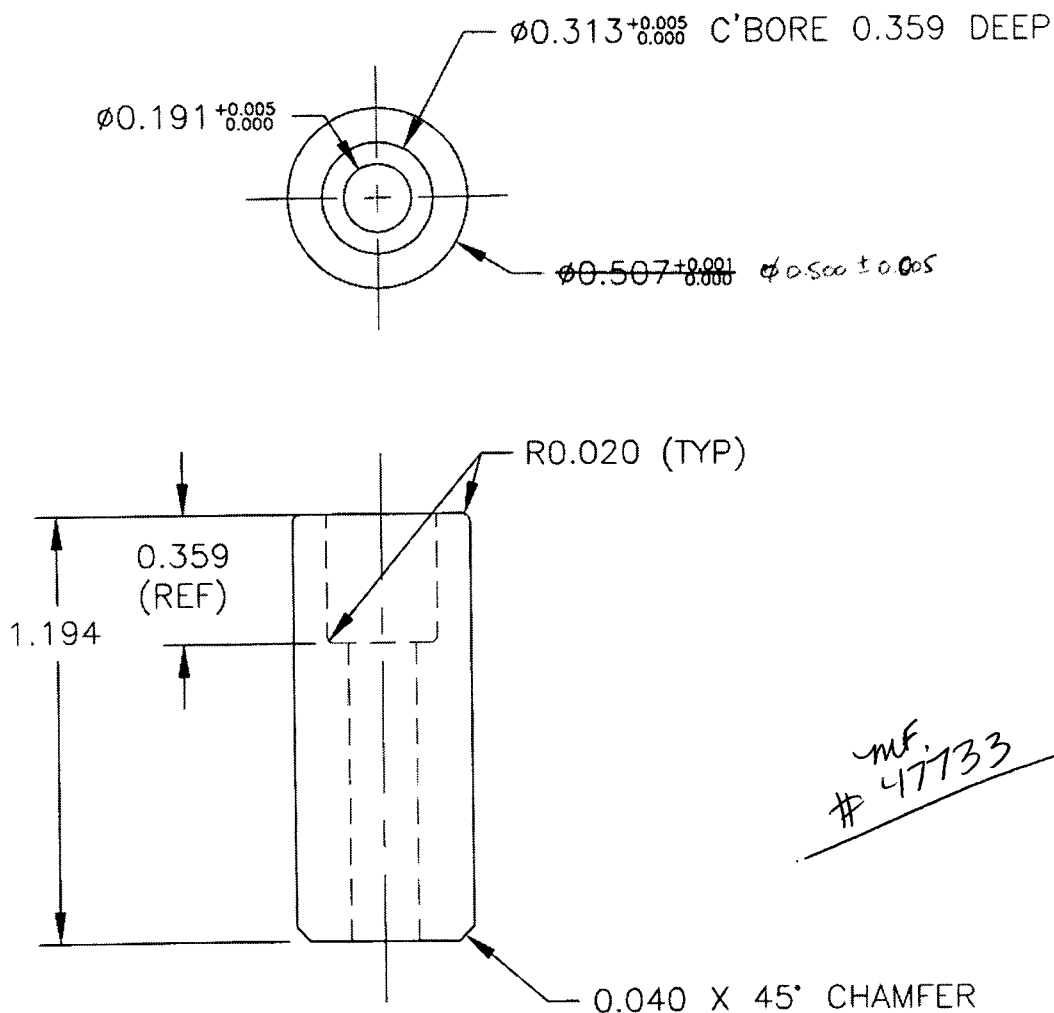
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01.04.26	ADD POWDER COAT; $\phi 0.500$ UN: $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4351) OR GREY SANDTEX (4356) OR BLACK SANDTEX (4357) OR GREEN SANDTEX (4358)

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REV DART QSI 005 4.1